

Work Order ID 127801-2

127801

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December-17-14 1:55:10 PM

Item ID: D2873-043

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Nut Plate Assembly

Start Date: 12/17/14 Start Qty: 40.00

40

Cust Item ID:

Required Date: 12/17/14 Req'd Qty: 40.00

40

Customer:

Reference:

Approvals: Process Plan: MLS Date: 14-12-23 Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2873	Rev A

100

0.00

100

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks: 1.000" x 0.375" x 3.700" long

DAS

37

9-89

15-01

110

0.00

110

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine as per Folio FA and Dwg D2873 Identify as D2873-3

Dwg Rev _____ Folio Rev _____

120

0.00

120

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

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Item ID: D2873-043

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N900040100

Setup Start ***NS1***

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Stop ***NS2***

Item Name: Nut Plate Assembly

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40

Required Date: 12/17/14 Req'd Qty: 40.00

40

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

40

0

DAS
37
9-89 15.01.11

140

Small Fab

0.00

140

Small Fab

Memo

0.00

Small Fab

1-Debur 2- C'sink as per Dwg D2873

40X

DAS
36
9-89 15/01/22

150

QC5- Inspect part completeness to step on W/O

0.00

150

QC

Memo

0.00

Quality Control

40

DAS
38
9-89

JAN 22 2015

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Item ID: D2873-043

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Nut Plate Assembly

Start Date: 12/17/14 Start Qty: 40.00

40

Required Date: 12/17/14 Req'd Qty: 40.00

40

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				40x	DAS 28 9-89		FEB 04 2015
170 *170* QC Quality Control	QC7-Inspect Chemical Conversion Coat Memo	0.00 0.00				40			DAS 38 9-89 FEB 05 2015
180 *180* Small Fab Small Fab	Small Fab Memo 1-Assemble as per Dwg D2873 2-Identify as D2873-043	0.00 0.00				25x			15/02/19 DAS 36 9-89

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Item ID: D2873-043 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Nut Plate Assembly
 Start Date: 12/17/14 Start Qty: 40.00 *40* Cust Item ID:
 Required Date: 12/17/14 Req'd Qty: 40.00 *40* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				(25)			38 9-89
200 *200* Packaging Packaging	Identify as per dwg & Stock Location: <u>LG052</u> Memo	0.00 0.00				25		15-02-21 2/	
210 *210* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00						15/2/23 2/	

FEB 20 2015

(15-2-23)

Picklist Print

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Page 1

Work Order ID: 127801

127801

Parent Item: D2873-043

D2873-043

Parent Item Name: Nut Plate Assembly

Start Date: 12/17/14

Required Date: 12/17/14

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP A05.09.13New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.375X01.00 0		Purchased	No			180	f	12.0000	0.3083	12.98105			

M6061T6B0 375X01 000

6061T6 BAR .375 x 1.00

**

Location Loc Qty Loc Code

MAT001 12
m128866 12
180 Each 2,103.000 6

**

Location Loc Qty Loc Code

GA 1088
M128812 1088
MF4 185
124392 185
ST312 830
124392 83
M128812 747

**

Location Loc Qty Loc Code

ST273A 482
m128578 482
ST300 7
123346 7

MS20426AD4-6

MS20426AD4-6

Rivet

Purchased

No

DAS
36
9-89

8.8
240
3-6
15/01/13
15/02/19
DAS
36
9-89

M130922 (138x)

M125807 (102x)

MS21075L5

MS21075L5

Nut Plate

Purchased

No

100 Each 489.0000 3

120

DAS
36
9-89

15/02/19

120

DART AEROSPACE LTD		Work Order: 127801
Description: Radius Block		Part Number: D2873-3
Inspection Dwg: D2873	Rev: A	Page 1 of 1

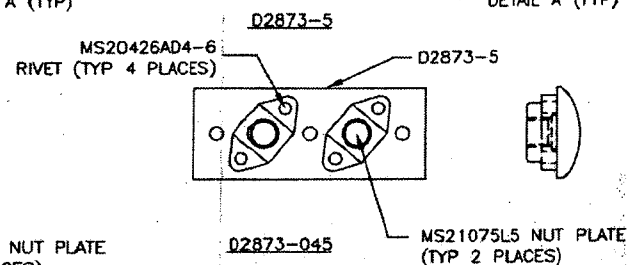
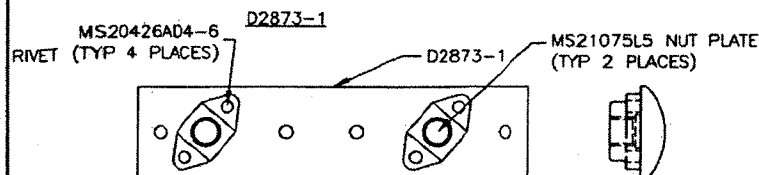
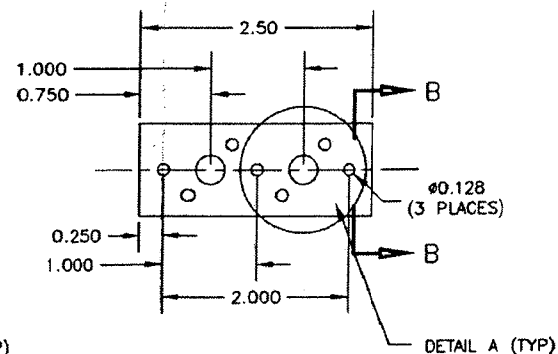
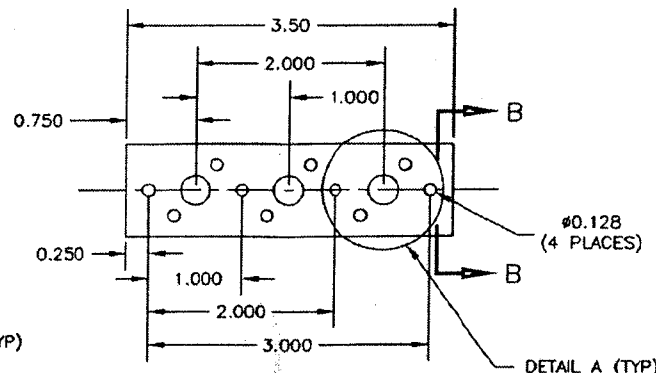
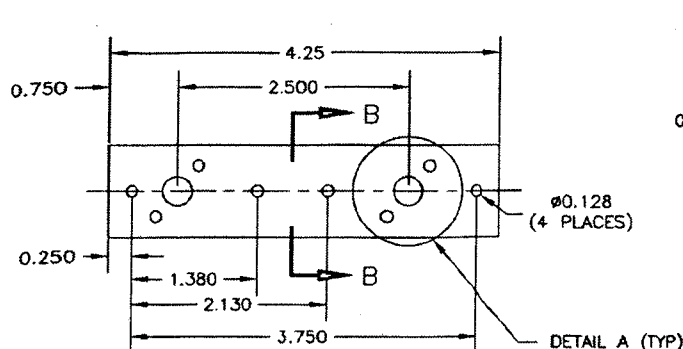
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.50	+/-0.030	3.501	✓		Gage Pin	
2.000	+/-0.010	2.001	✓		Vern LPO9	
0.750	+/-0.010	.750	✓		Mic LPO6	
1.000	+/-0.010	.996	✓		Vern LPO9	
0.250	+/-0.010	.250	✓		Mic LPO6	
1.000	+/-0.010	1.000	✓		Vern LPO9	
2.000	+/-0.010	2.001	✓		↓	
3.000	+/-0.010	3.001	✓		↓	
Ø0.128	+0.005/-0.001	.129	✓		Gage Pin	
0.359	+/-0.010	.359	✓		Vern LPO9	
Ø0.316	+0.006/-0.001	.317	✓		Gage Pin	
1.000	+/-0.010	1.00	✓		Vern LPO9	
0.250	+/-0.010	.250	✓		↓	
0.061	+/-0.010	.061	✓		↓	
Ø0.230 x 0.125	+0.005/-0.001 x 0.010	.230 x .127	✓		↓	

Measured by: [Signature] 15/01/14	Audited by: DAS 37 9-89	Prototype Approval:	N/A
Date:	Date: 15-01-15	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.08.30	New Issue P/O D2873-043	KJ/JLM	[Signature]



D2873-1/-3/-5 RADIUS BLOCK

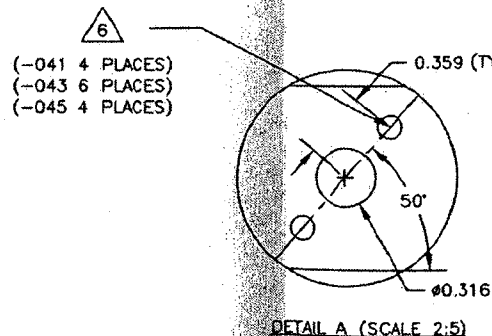
- 1) MATERIAL: 5052-H32/H34 BAR (QQ-A-225/7) (REF. DART SPEC M5052H32B1.000X00.250) OR 6061-T6 BAR (QQ-A-225/8 OR QQ-A-200/8) (REF. DART SPEC M6061T6B1.000X00.250)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 6) Ø0.128 PILOT + C'BORE CURVED SIDE Ø0.230X0.125 DEEP + C'SINK CURVED SIDE Ø0.225 x 100"

D2873-041/-043/-045 NUT PLATE ASSEMBLY

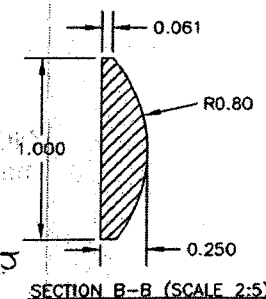
- 1) INSTALL MS21075L5 NUT PLATE IN ORIENTATION SHOWN USING MS20426AD4-6 RIVETS

D2873-041/-043/-045 NUT PLATE ASSEMBLY PARTS LIST

-041	-043	-045	PART NUMBER	DESCRIPTION
X			D2873-041	NUT PLATE ASSEMBLY
	X		D2873-043	NUT PLATE ASSEMBLY
		X	D2873-045	NUT PLATE ASSEMBLY
1			D2873-1	RADIUS BLOCK
	1		D2873-3	RADIUS BLOCK
		1	D2873-5	RADIUS BLOCK
4	6	4	MS20426AD4-6	RIVET
2	3	2	MS21075L5	NUT PLATE



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WITHOUT NOTICE
WORK ON FILE
NO. 127801MLJ



A	05.07.26	NEW ISSUE
DESIGN	PH	DART DART AEROSPACE LTD WINDSOR, ONTARIO, CANADA
CHECKED	PH	DART
DATE	05.07.26	DRAWING NO. D2873 TITLE RADIUS BLOCK SHEET 1 OF 1 SCALE 4:5

RELEASED
05.07.26